

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012952**Date Inspected:** 28-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard:

CB10.

This QA Inspector observed the following welding in progress:

Repair welding of weld joint FB204-025 – 050 & FB204-026 – 050. Welder was identified as 051359. Weld process used was Shielded Metal Arc Welding (SMAW) as per Welding Repair Report (WRR): B-WR 11375 R-0 & B-WR 11381 R-0; for the respective welds (against UT report no: B787-UT-12067). ZPMC Quality Control (QC) is identified as Yin Dong Hai & the welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair.

Repair welding of weld joint FB204-026 – 053. Welder was identified as 058087. Weld process used was SMAW as per WRR: B-WR 11382 R-0 (UT report no: B787-UT-12067). ZPMC Quality Control (QC) is identified as Yin Dong Hai & the welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-Repair.

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Repair welding of weld joint FB204-027 – 087. Welder was identified as 051359. Weld process used was SMAW as per WRR: B-WR 11401 R-0 (UT report no: B787-UT-12067). ZPMC Quality Control (QC) is identified as Yin Dong Hai & the welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G (3F)-Repair.

Repair welding of weld joint FB204-028 – 069. Welder was identified as 051359. Weld process used was SMAW as per WRR: B-WR 11418 R-0 (UT report no: B787-UT-12067). ZPMC Quality Control (QC) is identified as Yin Dong Hai & the welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair.

CB11, CB12, CB13, CB14 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Bay 1: CB15.

This QA Inspector observed the following work in progress:
ZPMC personnel doing grinding of weld profile of floor beam fillet welds with side panels and top panel. This QA Inspector did random visual inspection of the fillet welds after grinding & were found to be complying with the Contract documents. ZPMC QC inspector was identified as Tian Lei.

Bay 6: CB 9.

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 8:

This QA Inspector observed the following work in progress:
ZPMC personnel doing UT of welds of corner diaphragm assembly (for CB17). ZPMC UT technician was identified as Huang Jing. This QA Inspector did random visual inspection of the welds to be UT tested & were found to be complying with the Contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials

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for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer